

Work Order ID 86653

July-06-12 11:12:48 AM

86653

Page 1

Item ID: D2362-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Support Bracket

Start Date: 7/06/12

Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/27/12

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2362

Rev E1

100

0.00

100

HAAS 1

HAAS CNC VERTICAL MACHINING #1

0.00

Memo

HAAS CNC vertical machine #1

1- Mill as per Folio FA800 Rev: AA & Dwg D2362 Rev: E1 2-Debur
per dwg D2362

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

Quality Control

120

0.00

120

QC

QC8- Inspect parts - second check

0.00

Memo

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D2362-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Support Bracket
 Start Date: 7/06/12 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 7/27/12 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr								
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
140	Powdercoat	0.00							
Powder Coating	Memo								
	START TIME: 8:00								
	FINISH TIME: 8:30								
150	QC3- Inspect Part Finish	0.00							
150	QC	0.00							
Quality Control	Memo								

W121841

MT
10X
12/07/12

10x 4 11/07/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Item ID: D2362-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Support Bracket

Stop *NS2*

Start Date: 7/06/12 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 7/27/12 **Req'd Qty:** 4.00 *** / ***

Customer:

Reference:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

0.00

160

Small Fab

0.00

Small Fab

Memo

Small Fab

Bond rubber D2397-1 followed by D2397-3 using contact cement as per Dwg D2362
Batch 17122346

170

QC5- Inspect part completeness to step on W/O

0.00

170

Memo

0.00

OC

Quality Control

180

Identify as per dwg & Stock Location: 484 0.00

0.00

180

Memo

0.00

Packaging

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 4

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Support Bracket

Start Date: 7/06/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/27/12 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21 - Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/7/20 JJ

MF
12-07-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

July-06-12 11:12:48 AM

Page 1

Work Order ID: 86653

Parent Item: D2362-3

Parent Item Name: Support Bracket

Start Date: 7/06/12

Required Date: 7/27/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: G00.05.18Added inspection level 8EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2265 Step Bracket		Manufactured	No			160	Each	60.0000	1	4		8.2 12/07/11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST488		60							
				→ 44114		60				10.0			
X D2397-1 Rubber Cushion		Manufactured	No		87864	160	Each	1.0000	1	4		(10) FF 12-07-17	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		1							
				72737		1							
X D2397-3 Rubber Cushion		Manufactured	No		87865	100	Each	0.0000	1	4		(10) FF 12-07-17	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 86653
Description: Step Support Bracket		Part Number: D2362-3
Inspection Dwg: D2362 Rev: E1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.005 -0.000	Ø0.258	✓		VERN	GA-01
3.074	+/-0.010	3.074	✓		"	"
0.34	+/-0.030	0.329	✓		"	"
0.77	+/-0.030	0.791	✓		"	"
1.500	+/-0.010	1.500	✓		"	"
1.000	+/-0.010	1.010	✓		"	"
0.80	+/-0.030	0.778	✓		"	"
1.200	+/-0.010	1.203	✓		"	"
1.28	+/-0.030	1.275	✓		"	"
1.000	+/-0.010	1.002	✓		"	"
0.75	+/-0.030	0.760	✓		"	"
1.88	+/-0.030	1.872	✓		"	"

Measured by: B.A	Audited by: [Signature]	Prototype Approval:	N/A
Date: 12/07/11	Date: 12-7-11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF [Signature]	[Signature]

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT

WITH

WORK ORDER

NO.

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD	
BW	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
KE	#	D2362	SHEET 1 OF 3
DATE	TITLE		SCALE
98.12.04	STEP SUPPORT BRACKET		1:2
A	95.02.15	NEW ISSUE	
B	95.03.22	CHANGED RUBBER TO D2397	
C	96.01.22	ADD D2362-5	
D	97.05.21	ADD D2362-7	
E	98.12.04	REDRAWN, ADD 2397-5	

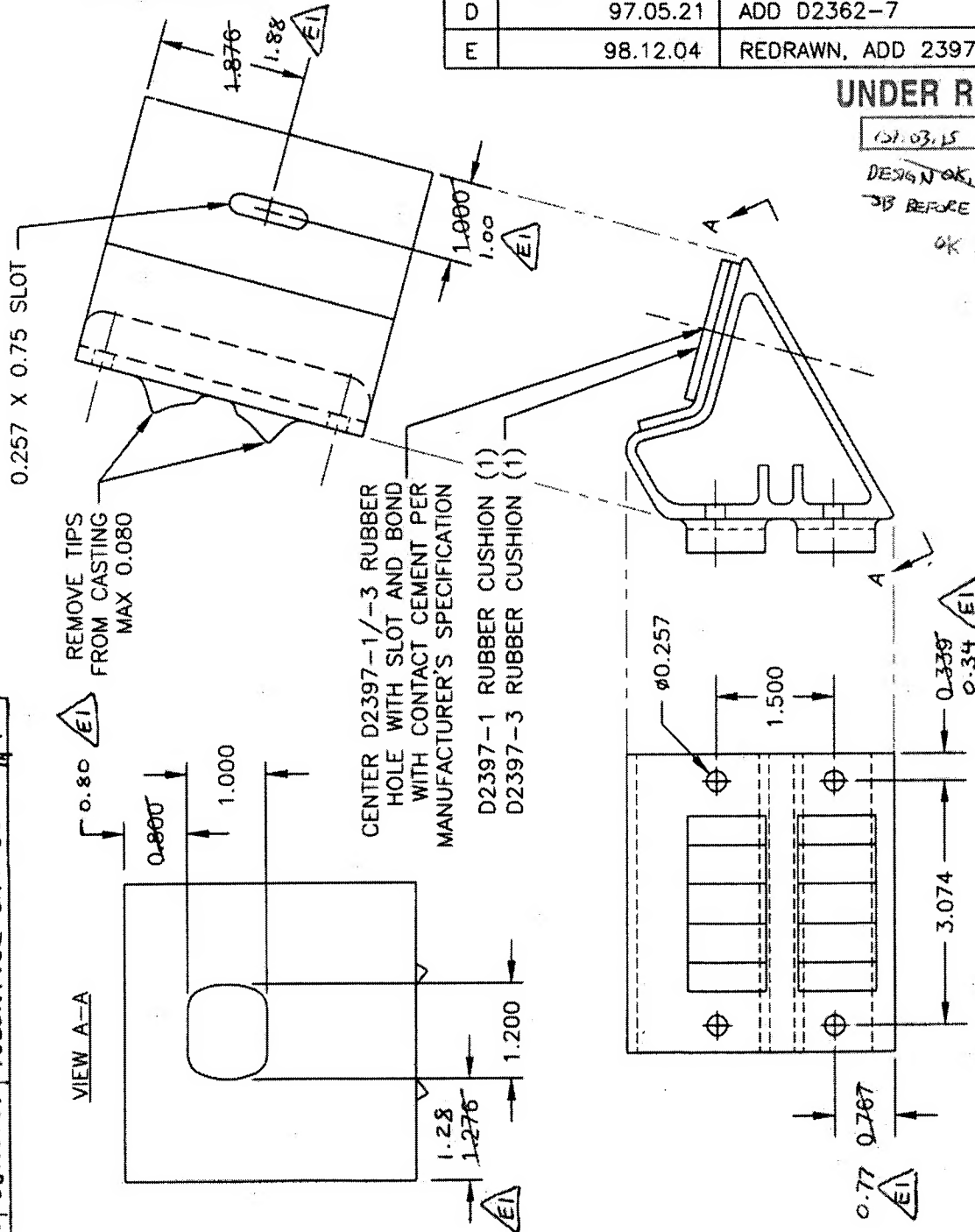
RELEASED
98.12.14 KE

UNDER REVIEW

121.03.15 CP

DESIGN OK, BUT CHECK WITH
3B BEFORE MANUFACTURE




OK CP 04.11.09

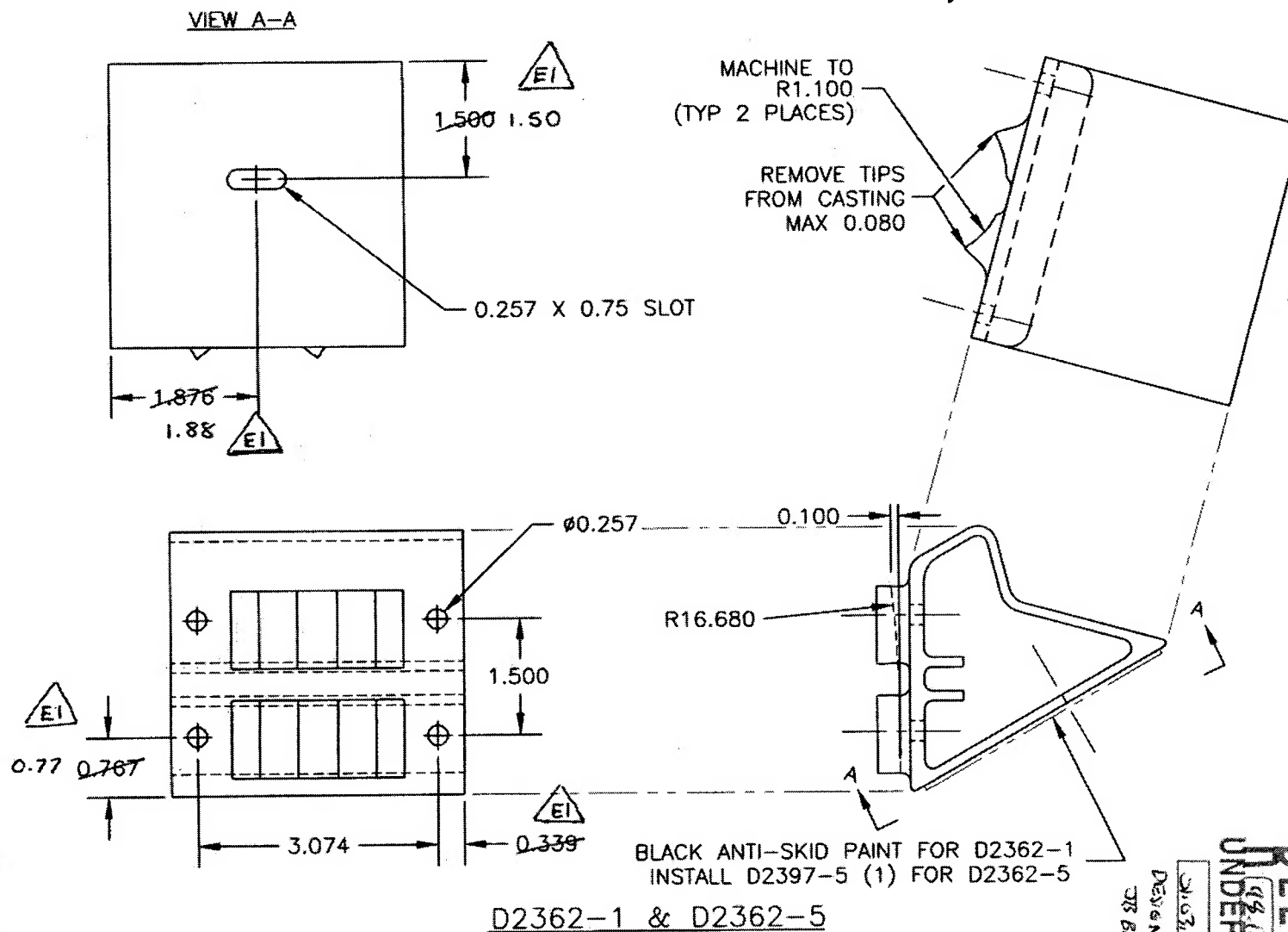


NOTES:
MAKE FROM D2265
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING RUBBER IN PLACE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DAFT



DESIGN	DRAWING BY		DARI AEROSPACE LTD		REV. E
BW			HAMKESBURT, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.		SHEET 2 OF 3	
		D2362			
DATE		TITLE		SCALE	
98.12.04		STEP SUPPORT BRACKET		1:2	



NOTES:

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

118-12-14 KE
UNDER REVIEW

03745 of
DENON, BUTTER BY
JESSE MANUFACTURE
OK 4/24/09



DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	MB	D2362
DATE	TITLE	SHEET 3 OF 3
98.12.04	STEP SUPPORT BRACKET	SCALE
		1:2

UNDER REVIEW

RELEASED
98.12.14 KE

010315 CP
DESIGN OK BUT CHECK WITH
DTS BEFORE MANUFACTURE

OK 04/11/04

86653

D2362-041 (SHOWN)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PAINT PER QSI 005 4.4 AFTER
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)

MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY

NOTES:

TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

